

Date: Wednesday, 3/26/2008 10:03:55 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 38201	
Estimate Number : 10494	
P.O. Number :	Part Number : D32045
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D3204 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 35876	Material :
Written By :	Due Date : 4/4/2008 Qty: 8 Um: Each
Checked & Approved By : <u>JD 08.3.27</u>	
Comment : Est:C 05.08.11 Added Step 25 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01250	6061-T6 Bar .375 x 1.25"
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Comment: Qty.: 0.3059 f(s)/Unit Total : 2.4469 f(s)

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)

(M6061T6B0.375x01.250)

Batch: M1103755

JD 08/03/30

(8)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000)

JD 08/03/30

(8)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA344 and Dwg D3204

2- Deburr

Identify as D3204-5

JD 08/06/01

P10 →

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JD 08/06/01

5.0	QC8	SECOND CHECK
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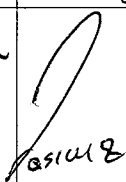



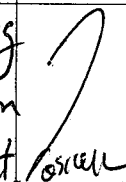
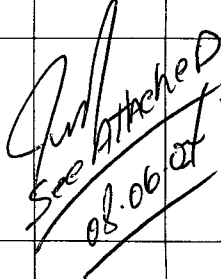





Comment: SECOND CHECK

JD 08/06/01 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3204-5 PAR #: N/A Fault Category: Prod Machine Part NCR: Yes No DQA: D Date: 08/06/09
 QA: N/C Closed: D Date: 08/06/10

NCR: 38201		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/09	3	2 parts have dimension -200 under tolerance		- scrap + replace qty @ B# <u>M103755</u>	J.L. 08/06/09			
		R.C. In proper Tooling for facing operation Have too shim the part.		Make Tooling to Prevent this prevent this from happening again	 See Attached 08.06.09			
		Need jaws for that operation. JF 08/06/09						

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 10:03:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 38201

Part Number: D32045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PAT. Duval

AS 08/06/05 *(28)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/09 *(18)*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

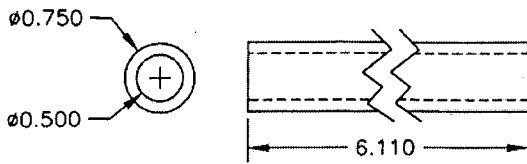
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

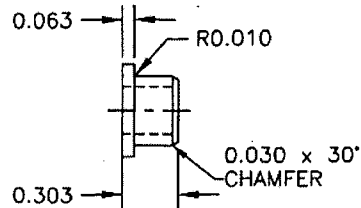


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

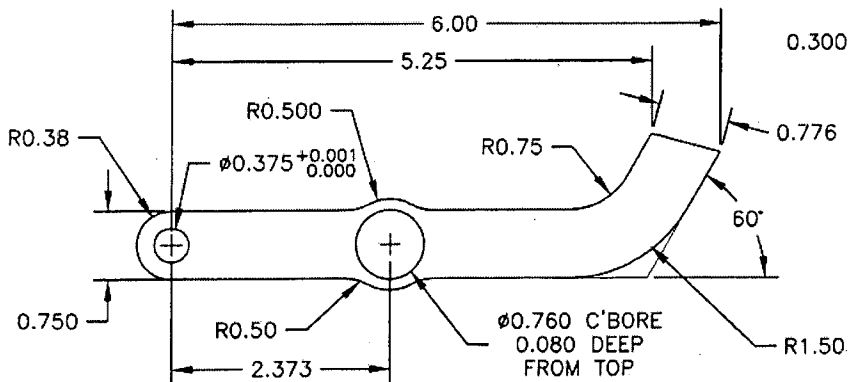
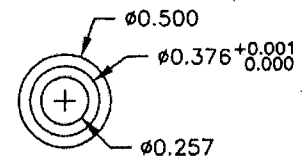
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04.04.05



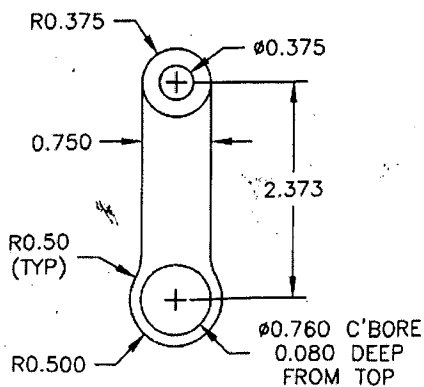
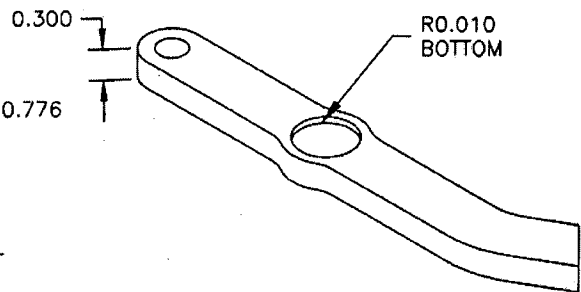
2 D3204-1 TUBE
SCALE 1:2



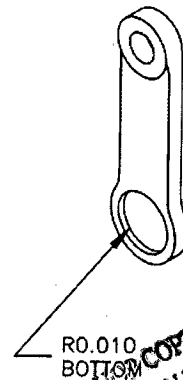
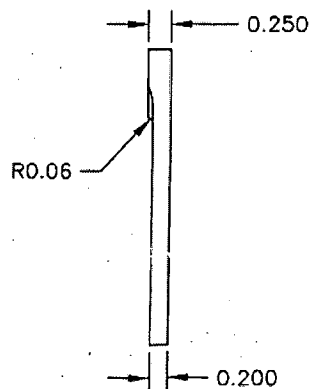
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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WITHOUT NOTICE
WORK ORDER

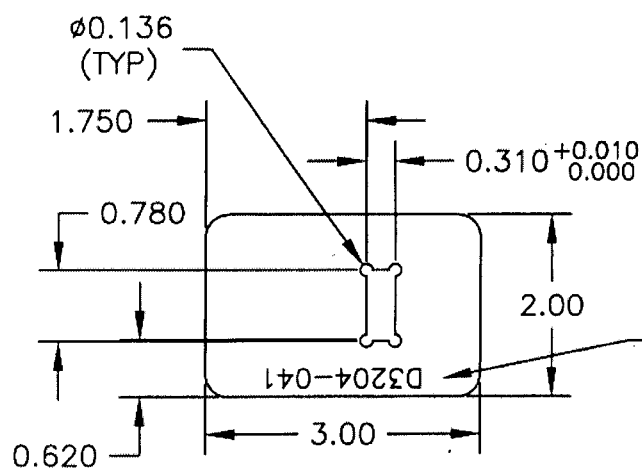
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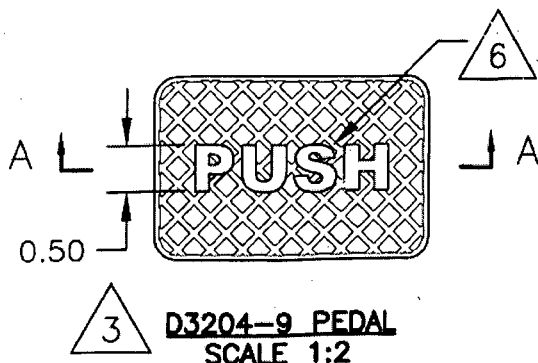


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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

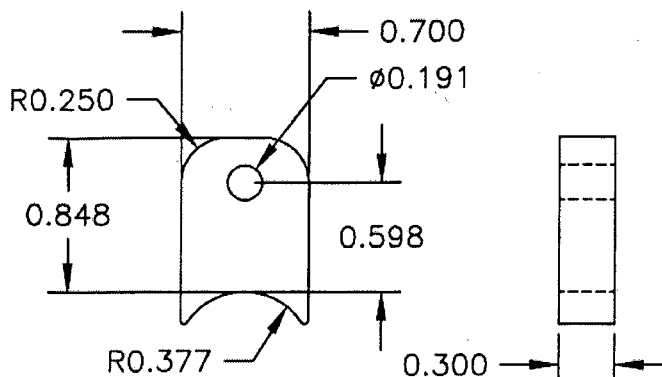
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04.04.30



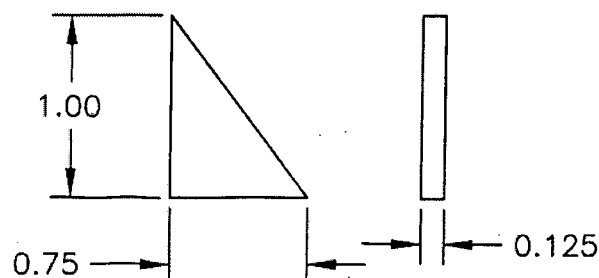
VIEW A-A
SCALE 1:2



D3204-9 PEDAL
SCALE 1:2



D3204-11 PLATE
SCALE 1:1



D3204-13 GUSSET
SCALE 1:1

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D3204-5 2ND OPERATION

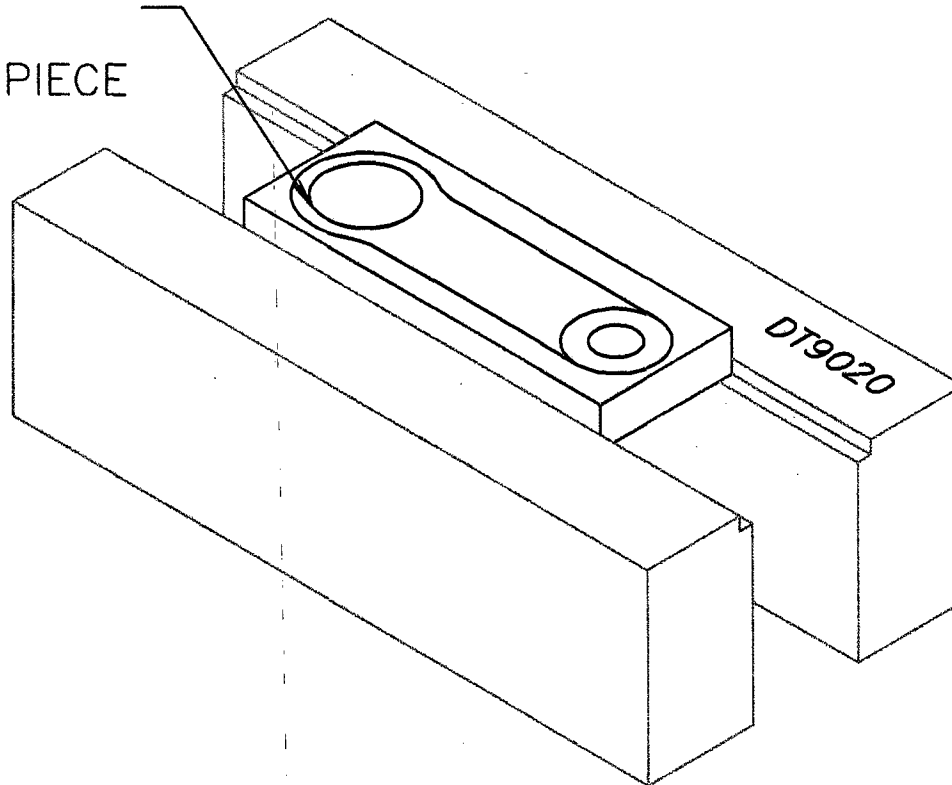
PROG #4000

G57:

X=0.0

Y=0.0(CENTER)

Z=0.0 BOTTOM OF PIECE



MACHINE JAWS WITH RECESS HOLDING BY .200" MAX